

# Work Order ID 66079

Thursday, February 03, 2011 3:10:11 PM



Page 1

Item ID:	D3254-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Side (RH)					
Start Date:	2/4/2011	Start Qty: 4.00		Cust Item ID:		
Required Date:	2/18/2011	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>mmf</u>	Date:	<u>11-02-03</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3254	Rev A

100		0.00							
	FLOW WATER JET	0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3254 <input type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u> <input type="checkbox"/> 2-Deburr if necessary								
<u>2624 .063</u>									<u>B11-3-10</u>

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									<u>B11-3-10</u>

120		0.00							
	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									<u>m</u> <u>11</u> <u>03</u> <u>10</u> <u>(4)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Thursday, February 03, 2011 3:10:11 PM



Page 2

Item ID: D3254-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Side (RH)

Start Date: 2/4/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Bend as per dwg D3254

0.00

0.00

SB 1/10/10

4

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

11 03 10 4

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

4 1/10/14

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Thursday, February 03, 2011 3:10:11 PM

Page 3

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Required Date:	2/18/2011	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M 112588.</i> Memo START TIME: <i>11:20</i> <i>320</i> FINISH TIME: <i>11:50.</i>	0.00  0.00				<i>H</i>	<i>BK</i>	<i>11-3-15.</i>	
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<i>4</i>	<i>9</i>	<i>11/03/15</i>	
180  Packaging Packaging	Identify as per dwg & Stock Location: <i>144</i>  Memo	0.00  0.00				<i>11/3/15</i>	<i>SP</i>	<i>CV</i>	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries


**Work Order ID 66079**

Thursday, February 03, 2011 3:10:11 PM

Page 4

Item ID:	D3254-2	Accept		Setup	Start	
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Required Date:	2/18/2011	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

MP  
11-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, February 03, 2011 3:10:03 PM

Page 1

Work Order ID: 66079



Parent Item: D3254-2



Parent Item Name: Side (RH)



Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 04.10.26 D3254-2 no longer made in-house  
IPP c 08.11.13 in-house EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 		Purchased	No			100	sf	55.9270	3.37	14.18947	16.		
2024-T3 .063 sheet												1311-3-10	

Location

Loc Qty

Loc Code

MAT22

55.927

114351

55.927

117018

117018

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

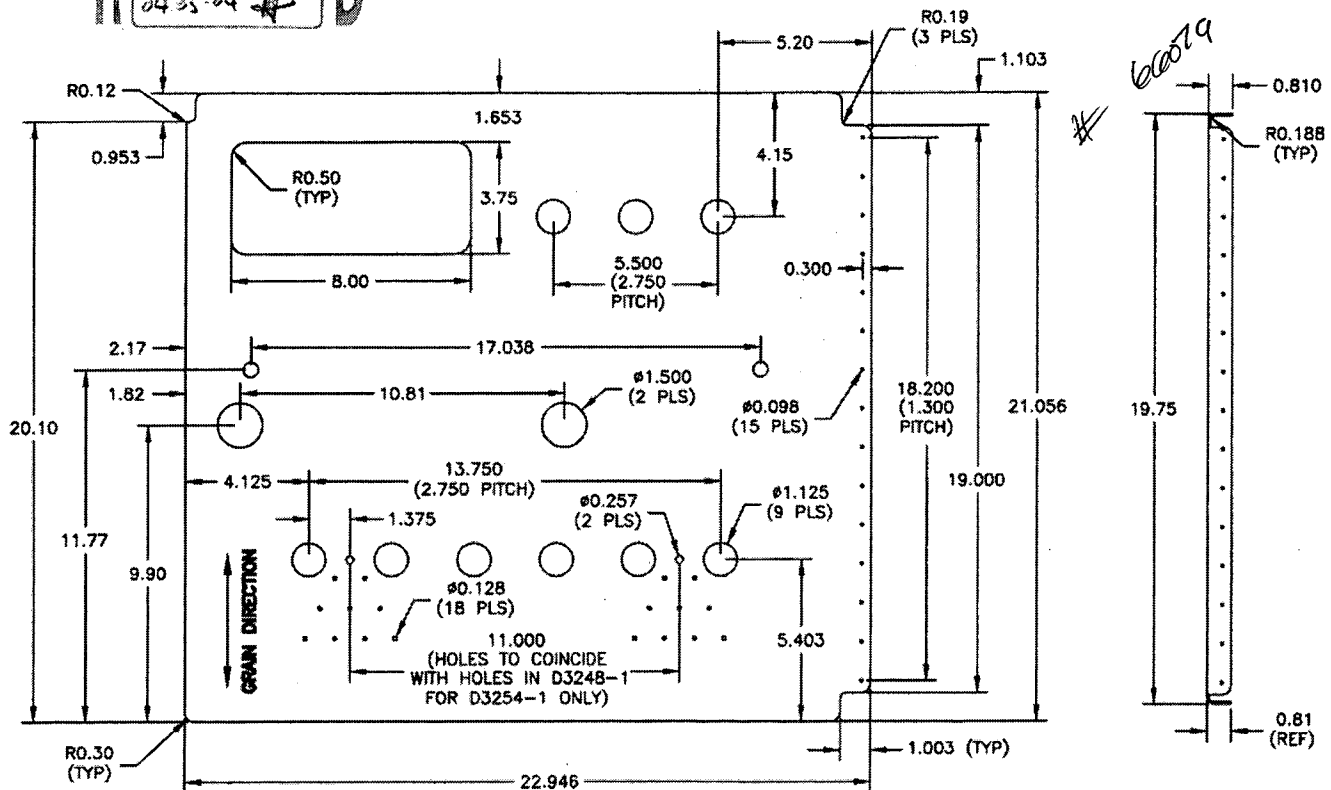
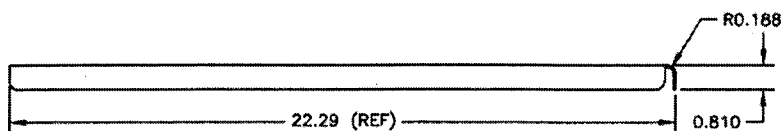
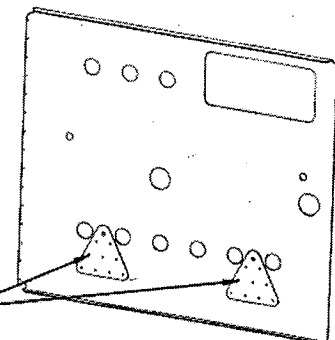
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED OP	APPROVED #	DRAWING NO. D3254	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE SIDE (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	

**RELEASED**  
04-05-04**D3254-1/-2 FLAT PATTERN****D3254-1 BEND DETAIL (SHOWN)  
D3254-2 OPPOSITE**INSTALL D3248-1  
USING MS20470A4-5  
RIVETS**D3254-041****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 06079
<b>Description:</b> Side (Dual Battery Rack)		<b>Part Number:</b> D3254-2
<b>Inspection Dwg:</b> D3254	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.20	+/-0.030	5.20	X		✓ HB02	
4.15	+/-0.030	4.141	X		✓	
R0.19	+/-0.030	.19	X		R.G.	
1.103	+/-0.010	1.110	X		✓	
0.300	+/-0.010	.297	X		✓	
Ø0.098	+0.005/-0.000	.103	X		✓	
1.300 Pitch	+/-0.005	1.306	X		✓	
21.056	+/-0.010	21.056	Ø		T HB01	
19.000	+/-0.010	19.000	Ø		T	
1.003	+/-0.010	1.009	X		✓	
Ø1.125	+0.005/-0.000	1.129	Ø		✓	
5.403	+/-0.010	5.402	Ø		✓	
Ø1.500	+0.005/-0.000	1.503	X		✓	
2.750 Pitch	+/-0.005	2.746	X		✓	
5.500	+/-0.010	5.495	L		✓	
1.653	+/-0.010	1.655	L		✓	
3.75	+/-0.030	3.750	Ø		✓	
10.810	+/-0.010	10.814	Ø		PRO W302	
8.00	+/-0.030	8.004	L			
R0.50	+/-0.030	.50	X		R.G.	
2.750 Pitch	+/-0.005	2.747	X			
4.125	+/-0.010	4.125	Ø		✓	
22.946	+/-0.010	22.946	X		T	
R0.30	+/-0.030	.30	X		R.G.	
9.90	+/-0.030	9.903	L		PRO	
11.77	+/-0.030	11.780	X		PRO	
1.82	+/-0.030	1.824	L		✓	
2.17	+/-0.030	2.165	L		✓	
20.10	+/-0.030	20.10	X		T	
0.953	+/-0.010	.959	X		✓	
R0.125	+/-0.010	.125	X		R.G.	
Grain along 20.10	N/A					

<b>Measured by:</b> RB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-3-10	<b>Date:</b> 11-03-10	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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